

Date: Tuesday, 12/5/2006 8:16:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TOW RING	
Job Number	: 29791				
Estimate Number	: 10396				
P.O. Number	: N/A		Part Number	: D2968041	
This Issue	: 12/5/2006		S.O. No.	: N/A	
Prsht Rev.	: NC		Drawing Number	: D2968	
First Issue	: N/A		Project Number	: N/A	
Previous Run	: 28267		Drawing Revision	: B1	
Written By			Material	: N/A	
Checked & Approved By			Due Date	: 12/23/2006	
Comment	: Est:C 03.04.11		Qty:	46	Um: Each
Reformat; Incorporated D2968-1/5 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	29791A	STEM	
<input checked="" type="checkbox"/> Comment: Sub-Component STEM D2968-1 B <u>B29791A</u> → 46 D29791A Cpl 06.12.14 (46)			
2.0	29791B	RING	
<input checked="" type="checkbox"/> Comment: Sub-Component RING D2968-5 B <u>29353B</u> → 41 29353B 29791 → 5 Cpl 06.12.14 (46)			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
<input checked="" type="checkbox"/> Comment: LARGE FABRICATION RESOURCE 1 Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041 Batch: <u>M15684</u> Cpl 06.12.14 (46)			
4.0	QC9	VISUAL WELDING INSPECTION	
<input checked="" type="checkbox"/> Comment: VISUAL WELDING INSPECTION Cpl 06.12.14 (46)			
5.0	QC5	INSPECT WORK TO CURRENT STEP	
<input checked="" type="checkbox"/> Comment: INSPECT WORK TO CURRENT STEP Cpl 06.12.14 (46)			
6.0	PG	PURCHASING	
<input checked="" type="checkbox"/> Comment: PURCHASING Issue P/O: <u>2760</u> Cpl 06.12.14 (46) Description: D2968-041 to heat treat to ultimate tensile strength 125ksi as per Dwg D2968 Conformity sheet required			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:16:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 29791

Part Number: D2968041

Job Number:



Seq. #: Machine Or Operation:

Description :

Issue P/O: 2761
Cad Plate per QQ-P-416F Class I Type II
Conformity sheet required

C 206112121
(46)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

P 201/11 *(46)*

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

J 07.01.15 (46)

9.0 POWDER COATING POWDER COATING



102391

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3
DO NOT POWDER COAT THREADS

P 201/11 07/01/16 (46)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 201/11

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST113

P 201/11 (46)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/17

Job Completion



07/01/17

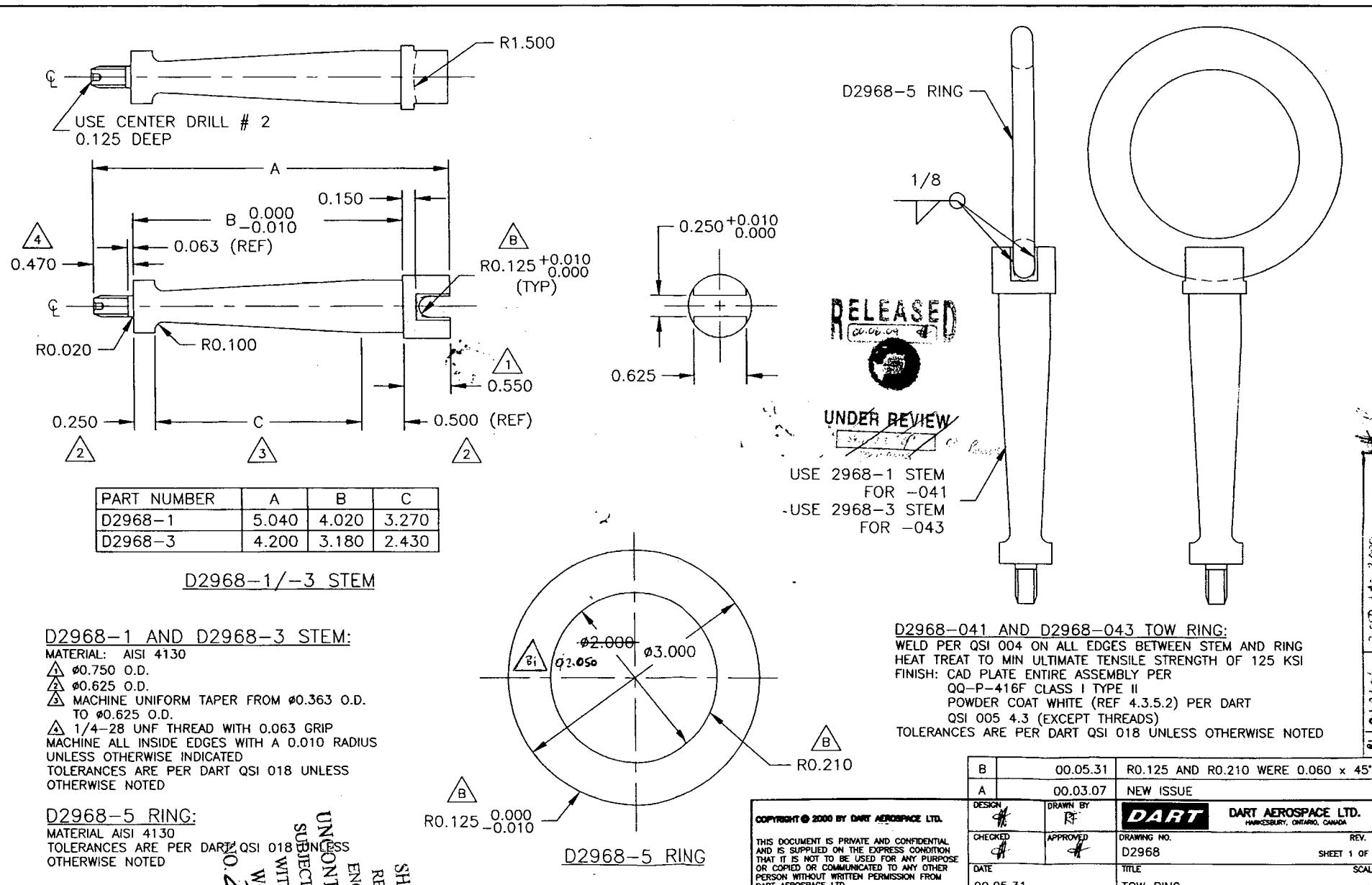
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



B	00.05.31	RO.125 AND RO.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	REV. B SHEET 1 OF 1 TITLE TOW RING	

00.05.31

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 29791

SHOP COPY
 RETURN TO
 ENGINEERING

DOMPLEX

Anjou (Québec) H1J 1B6

Tél.: 514-355-7867

Fax: 514-355-8750

**CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE**

#13051

DART Aerospace Ltd

Client / Customer

JO 2761
Votre # de commande / Your purchase order #D968-041 629791
de la pièce / part #101866

Notre # de bon de livraison / Our packing slip #

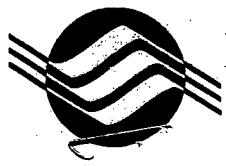
Inspecteur / Inspector	<u>Reneelet</u>	Date, équipe / Date, shift	<u>JAN 08 2007</u>
Placage / Plating	<u>QQP-416 F CLASS 1 T/Plat</u>		
Quantité totale / Total quantity	<u>46</u>	Quantité inspectée / Inspected quantity	<u>46</u>
Adhésion / Adhesion			
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / aver. <u>0.0005</u>
Coulisses, taches / Leach, spots	<u>No</u>	Rugosité / Roughness	<u>10</u>
Quantité approuvée / Approved quantity	<u>46</u>	Quantité rejetée / Rejected quantity	<u> </u>

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf ofMANCO
DOMPLEX



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No. : R105468102

OAK 82767-1

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

01/04/2007

MM / DD / YYYY

PAGE : 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO : MANCO DOMPLEX
4660 HICKMORE
ST-LAURENT, QC

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
01/04/2007		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO000002760		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-041	B29791 TOW RING	EA	46	46	

Process Specifications: Procedure: 4047

HEAT TREATED TO 125 KSI MIN.

100% HARDNESS TESTED PER ASSTM E-18, HRC 27-32.5

MATERIAL: 4130

100% HARDNESS TESTED

46 pcs → 29/30 HRC

V.A.I.
TH.
27
Q.C.

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

VATD.
TH.
27
QC

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT
TREATING